

Work Order ID 56315-2

February 17, 2010 2:36:03 PM



Page 1

Item ID: D3774-1

Accept



Setup Start



Revision ID:

Item Name: Seat Bottom, LH/RH

Stop



Start Date: 2/17/10 Start Qty: 4.00



Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10-2-17

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3774

Rev B

100

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Set up machine program D3774-1 Set up clamping frame as per folio

BB
10/02/23

110

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks

BB
10/02/23

120

0.00



THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D3774-1 and Folio Dwg. Rev.

Folio Rev.

DRYSHEET IN 10/02/23 4:31
OUT 255F
6:30A

BB
10/02/24
X6

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Page 3

Item ID: D3774-1

Accept

Revision ID:

Item Name: Seat Bottom, LH/RH

Start Date: 2/17/10 Start Qty: 4.00

Required Date: 2/24/10 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: Date:

QC: Date:

Tooling: Date:

SPC (Y/N): Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8.10.03.02
(2-16)

(X5)

170



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

10/3/3 (5)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/03/03

MF
10-3-3

Picklist Print

February 17, 2010 2:36:07 PM

Page 1

Work Order ID: 56315



Parent Item: D3774-1



Parent Item Name: Seat Bottom, LH/RH

Start Date: 2/17/10

Required Date: 2/24/10

Comments: IPP REV:A New Issue 08.06.04 DL verified by:DD
IPP REV. B Dwg. Update 08.08.19 DL

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			110	sf	586.0519	42.6680			



GE PLASTICS LEXAN SHEET

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

586.051898

103106

1.6765

105330

37.8767

109455

40.5717

111710

265.893632

112585

240.033366

BB

10/02/23

10/02/23
X

DART AEROSPACE LTD		Work Order:	56315
Description: Seat Bottom		Part Number:	D3774-1
Inspection Dwg: D3774	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

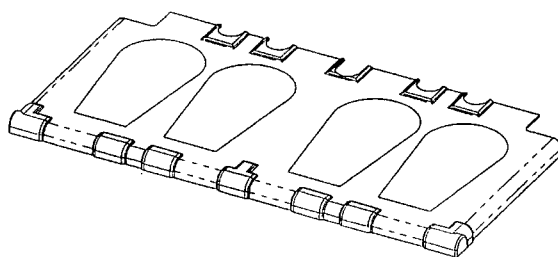
Measured by: JB	Date: 10/02/24
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TRIMMING SECTION

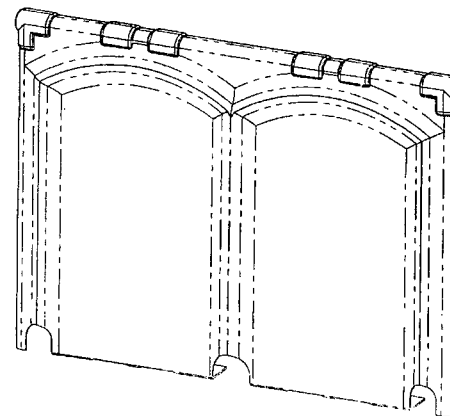
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3	+/-0.100	1.32	✓			
33.9	+/-0.100	33.875	✓			
17.4	+/-0.100	17.5	✓			
0.085	Min	.114	✓			
0.100	Min	.111	✓			
0.100	Min	.118	✓			
0.100	Min	.118	✓			
0.100	Min	.105	✓			

Measured by: JB	Date: 10/02/24
Audited by: [Signature]	Date: 10/02/24
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DL [Signature]	[Signature]



D3774-1 SEAT BOTTOM

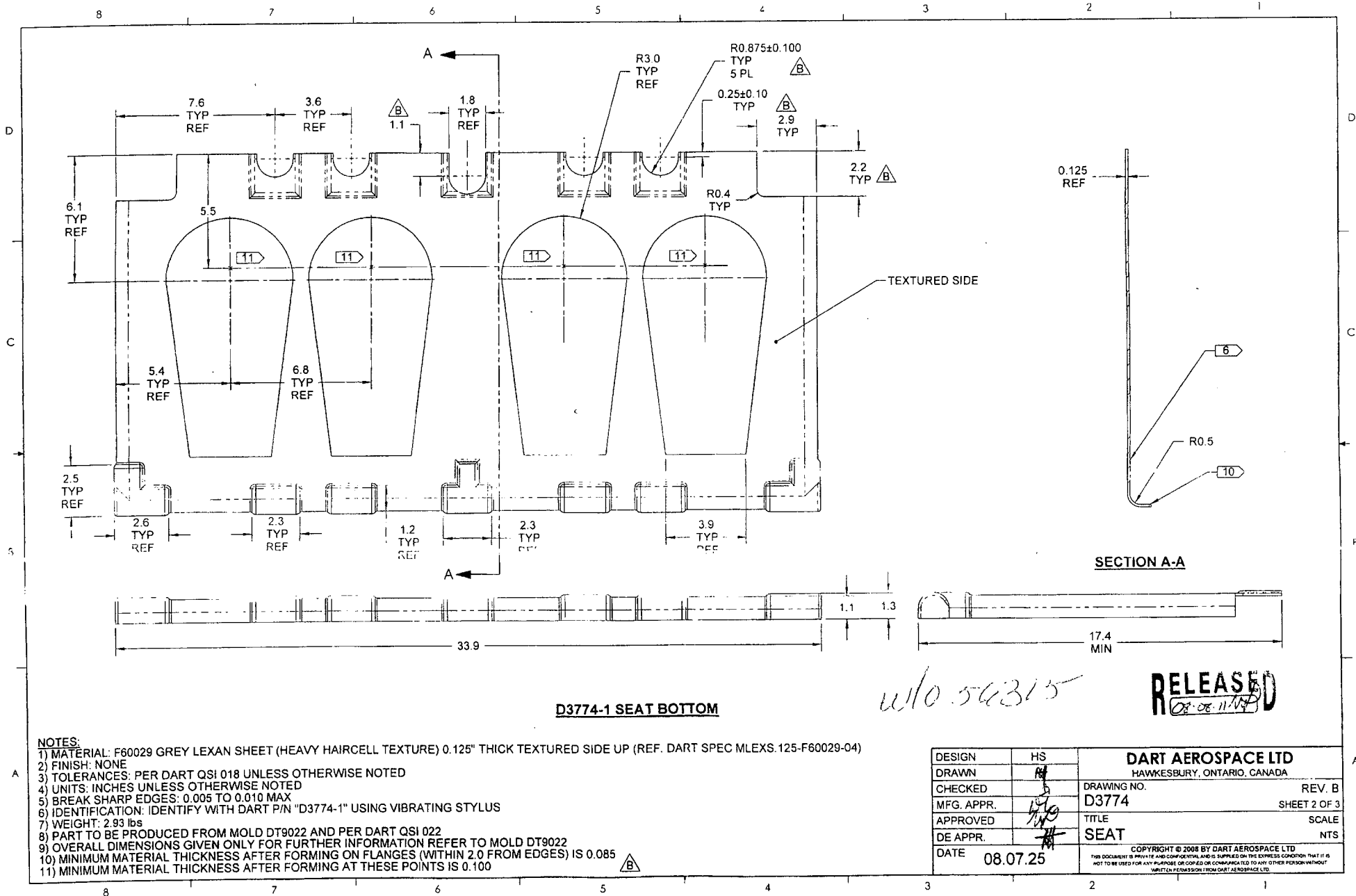


D3774-3 SEAT BACK

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54315
BY 10-2-17

RELEASED
06-08-11/11

B	UPDATE CUTOUT DIMENSIONS (ZN D4-2, D6-2, C4-3, C7-3); UPDATE MINIMUM THICKNESS (ZN A5-2, A5-3); ADD HOLES ON D3774-3 (ZN B6-3) REASON: MANUFACTURING CAPABILITIES	PH	08.07.25
A	NEW ISSUE	HS	08.06.23
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3774 TITLE SEAT SCALE NTS DATE 08.07.25 <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	PH		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH	REV. B SHEET 1 OF 3	



8

7

6

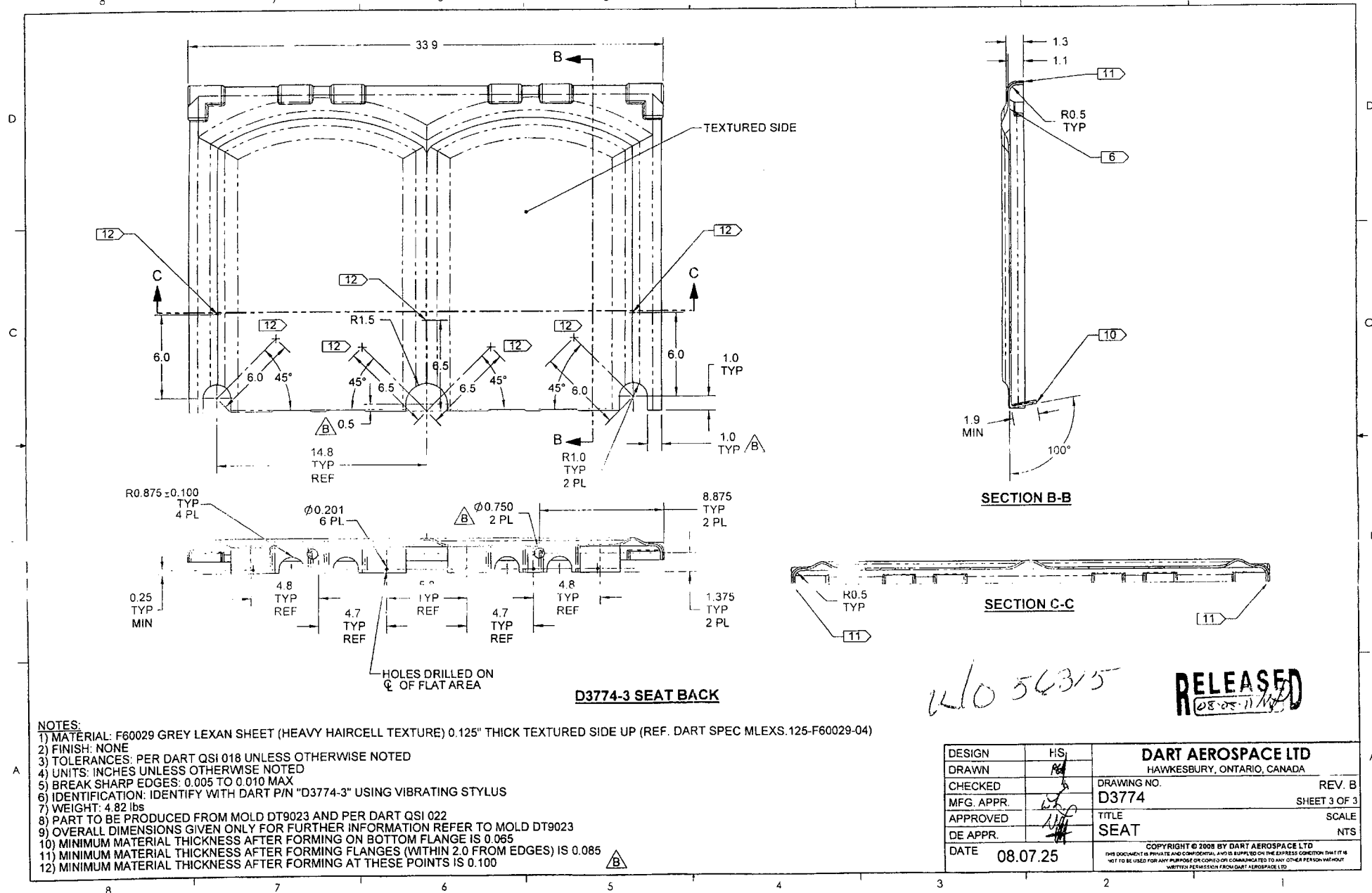
5

4

3

2

1



SECTION B-B

SECTION C-C

D3774-3 SEAT BACK

RELEASED

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS	DRAWING NO.	REV. B
CHECKED	HS	D3774	SHEET 3 OF 3
MFG. APPR.	HS	TITLE	SCALE
APPROVED	HS	SEAT	NTS
DE APPR.	HS	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE UNLESS SPECIFICALLY AUTHORIZED BY DART AEROSPACE LTD	
DATE	08.07.25		

Daryl Leger

From: Jason Murdoch [jmurdoch@dartaero.com]
Sent: Tuesday, February 23, 2010 3:33 PM
To: 'Chris Provencal'; 'Daryl Leger'
Cc: 'Linda Lacelle'
Subject: RE: Manufacturing Polycarbonate

Daryl,
 Must record.

Jason Murdoch
Quality Coordinator
 jmurdoch@dartaero.com
 DART Aerospace Ltd.
 613-632-5200

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: February 23, 2010 3:31 PM
To: 'Daryl Leger'
Cc: 'Jason Murdoch'; 'Linda Lacelle'
Subject: RE: Manufacturing Polycarbonate

I'm OK with making the seat bottoms, the existing folio should be followed.

Should record:

Drying

- The time when sheets were placed in the oven
- Temperature
- Time when removed

Forming

- Time when sheet formed
- Mold Temp
- Sheet Temp just before molding
- Release Temp

Plus whatever dimensions and additional checks that are normally measured.

- Chris

From: Daryl Leger [mailto:dleger@dartaero.com]
Sent: February 23, 2010 2:16 PM
To: cprovencal@dartaero.com
Cc: Jason Murdoch; Linda Lacelle
Subject: Manufacturing Polycarbonate
Importance: High

Chris:

Linda is in dire need for at least 1 D3774-1 aft facing seat bottom. We have an order for 4 so I would like to make a total of 5.

Because we have had discussion on parameters for manufacturing and have a sense of where we want to be with this, I would like to produce these for her tomorrow morning using the outlined parameters listed below.

We will dry the 0.125" lexan sheet at the recommended temperature of 255 deg. F., overnight for 15hrs. (The recommended time

2/24/2010

Took 1 hr 45 to get ideal pair

*✓ TIGAT - 60 - 258
 TIGAT - 75 - 270
 Just - 75 - 273
 No GRAB - 67 - 280
 Tee Hat - 67 - 289*

Sheets @ 73 F @ start

8:40	8:36	8:29	8:46	8:58	9:11
336	337	339	337	339	338
340	340	340	340	340	340
258	270	273	280	289	279

is about 10 hrs. for 4 mm sheet, but there is no sense in having someone come in early just to remove the sheet.)
We will form them on a mould preheated to approx 240deg.F., then cool without fans to a surface temperature of approx. 270 deg.
F. at which time they will be parted from the mould.
All other existing info on the folio and IPP will not change.

We will document the added steps and requirements on the WO.

Are you OK with this.

RSVP

Daryl L. Leger

Production Engineering Co-ordinator

DART

aerospace

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